

Work Order ID 71728

Monday, July 11, 2011 11:07:02 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 7/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: Date: 7-07-11 Tooling: Date: QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100 Weld per dwg A/R S.S. rod Batch: 117884 0.00

Large Fab

Large Fab

Memo 0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

PL 11-07-02

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

PL 11-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	7/21/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00							
130 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo *** mask sides of hinge prior to powdercoat*** Start Time: 9:00 Oven Temperature: 320° Finish Time: 10:20	0.00							
140 	Wing Walk as per dwg QSI005 4.4 Batch 117863	0.00							
HandFinish Hand Finishing	Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***	0.00							

1 11 01 25 (1)

1 0 BR 11-7-26

1 BR 11-7-26

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Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	d	11/07/02	
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>6-A</i> Memo <i>W/b</i> <i>71727</i>	0.00 0.00							<i>ES 11/08/02</i>
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>CK 11/08/02</i>

11-08-02
U

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Picklist Print

Monday, July 11, 2011 11:07:08 AM

Page 1

Work Order ID: 71728

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/11/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

83.0000

2

2



Mounting Bracket



PL 11.07.22

Location

Loc Qty

Loc Code

WA

83

69258

28

69739

4

70766

51

D3914-1

Manufactured

No

100

Each

7.0000

2

2



Rib



PL 11.07.22

Location

Loc Qty

Loc Code

WA

3

71392

3

WA006

4

69520

4

D3914-7

Manufactured

No

100

Each

8.0000

2

2



Rib



PL 11.07.22

Location

Loc Qty

Loc Code

WA

8

70335

4

71481

4

5

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Monday, July 11, 2011 11:07:08 AM

Page 2

Work Order ID: 71728

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/11/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

10.0000

3

3



Hinge Half, Lid



PL 11.07.22

Location

Loc Qty

Loc Code

WA

10

69164

4

70373

6

1

2

D4018-5 Manufactured No

100 Each

29.0000

9

9



Rib



PL 11.07.22

Location

Loc Qty

Loc Code

WA

15

69163

15

WA005

14

67041

14

4

3

D4020-5 Manufactured No

100 Each

4.0000

1



Mesh (350 Basket Long, Lid)



PL 11.07.22

Location

Loc Qty

Loc Code

WA

4

68234

1

69162

1

70239

2

1

D4021-3 Manufactured No

100 Each

4.0000

1

1



Data Plate



PL 11.07.22

Location

Loc Qty

Loc Code

WA005

4

70240

4

1

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Picklist Print

Monday, July 11, 2011 11:07:08 AM

Page 3

Work Order ID: 71728

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/11/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100 Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA006

3

69727

3

D4035-043

Manufactured No

100 Each

2.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

2

69869

2

D2728-3

Manufactured No

140 Each

0.0000

1



Dart Logo label

PL 11-07-22

PL 11-07-22

PL 11-7-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

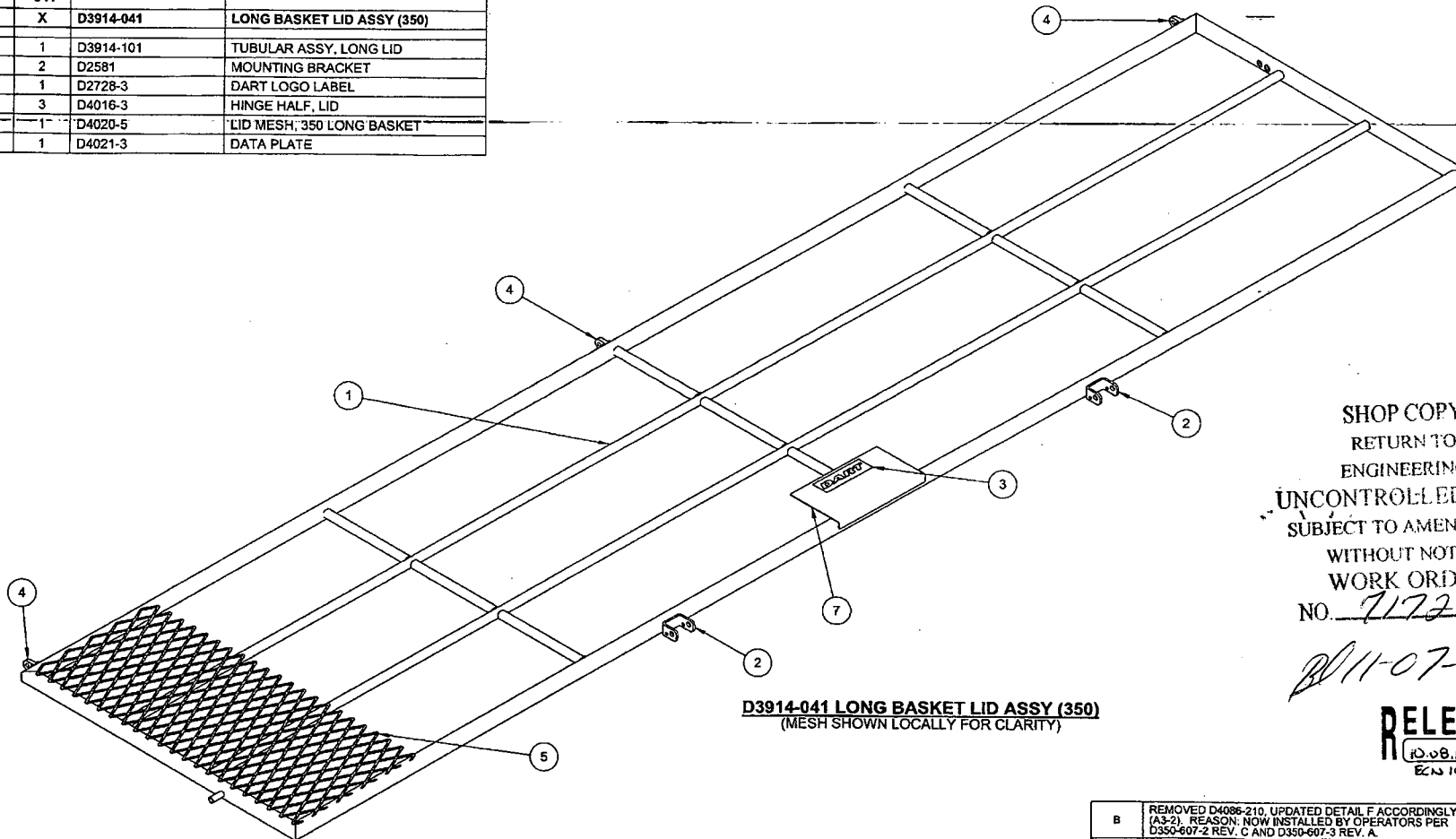
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71728

2011-07-11

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SC</i>	D3914	SHEET 1 OF 4
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

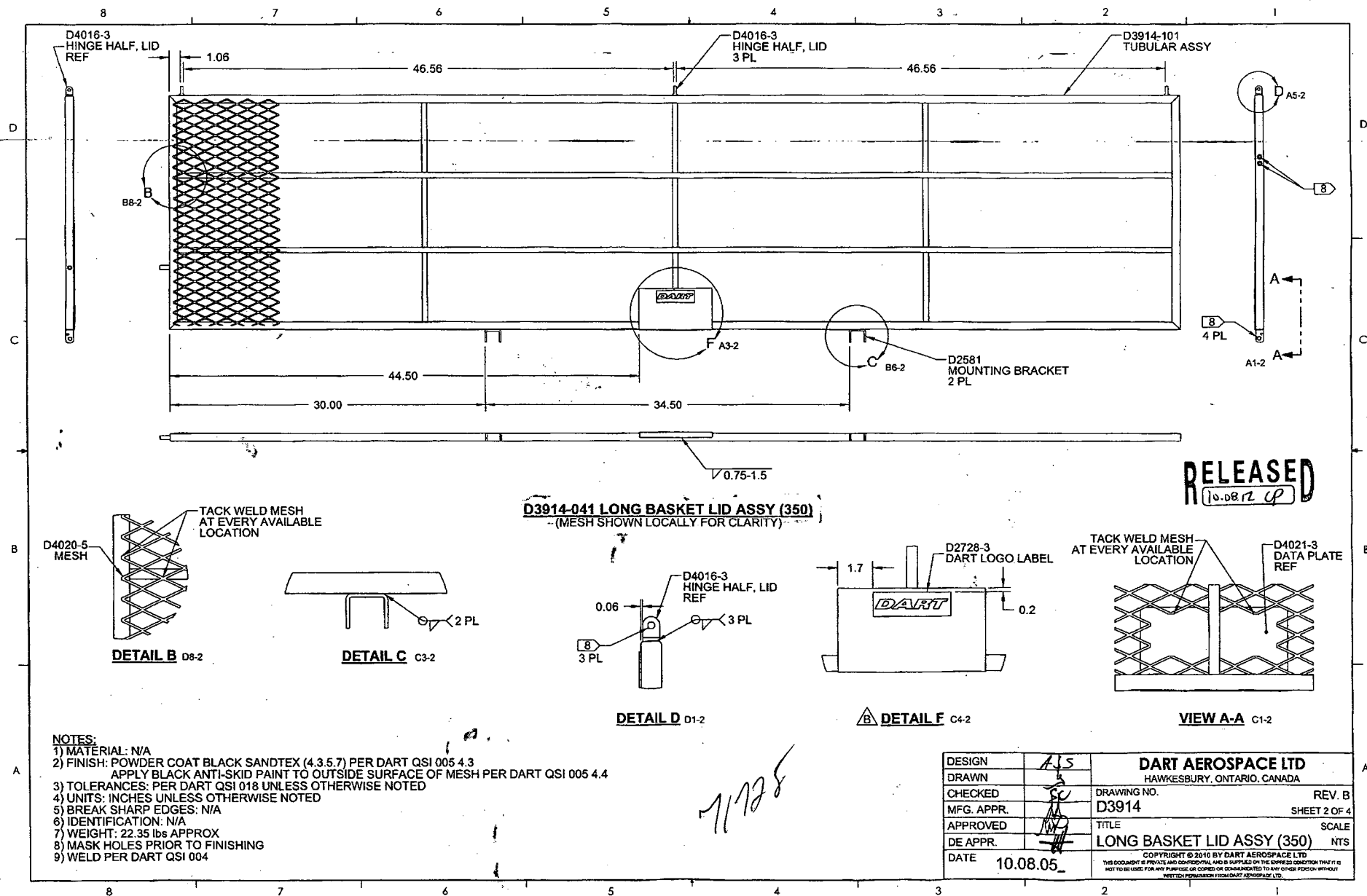
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Dart Aerospace Ltd

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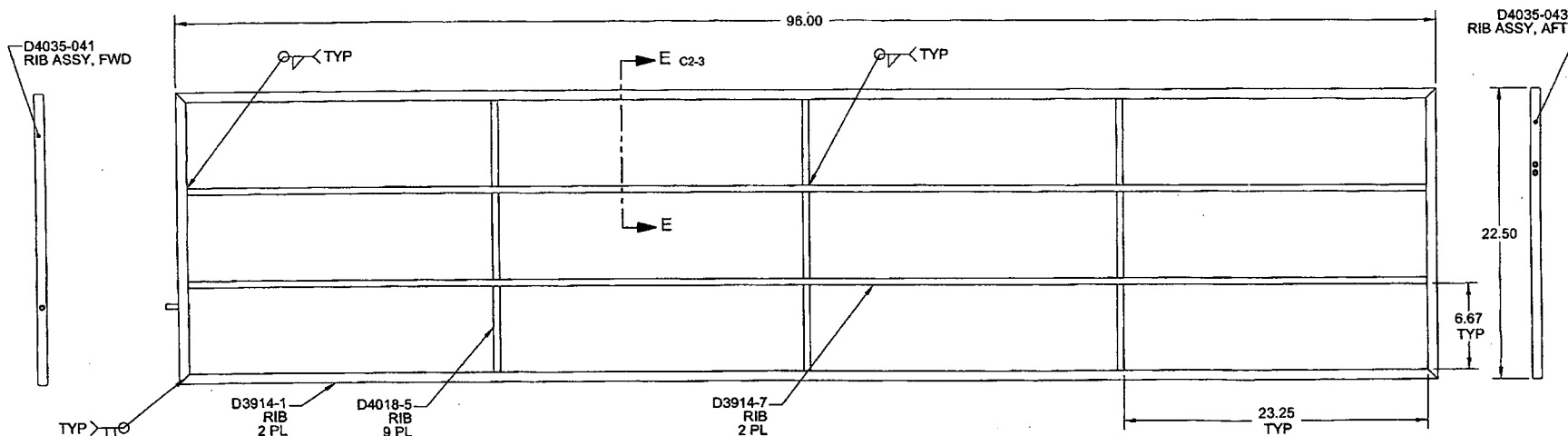
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	115	DART AEROSPACE LTD	
DRAWN	115	HAWKESBURY, ONTARIO, CANADA	
CHECKED	115	DRAWING NO.	REV. B
MFG. APPR.	115	D3914	SHEET 3 OF 4
APPROVED	115	TITLE	SCALE
DE APPR.	115	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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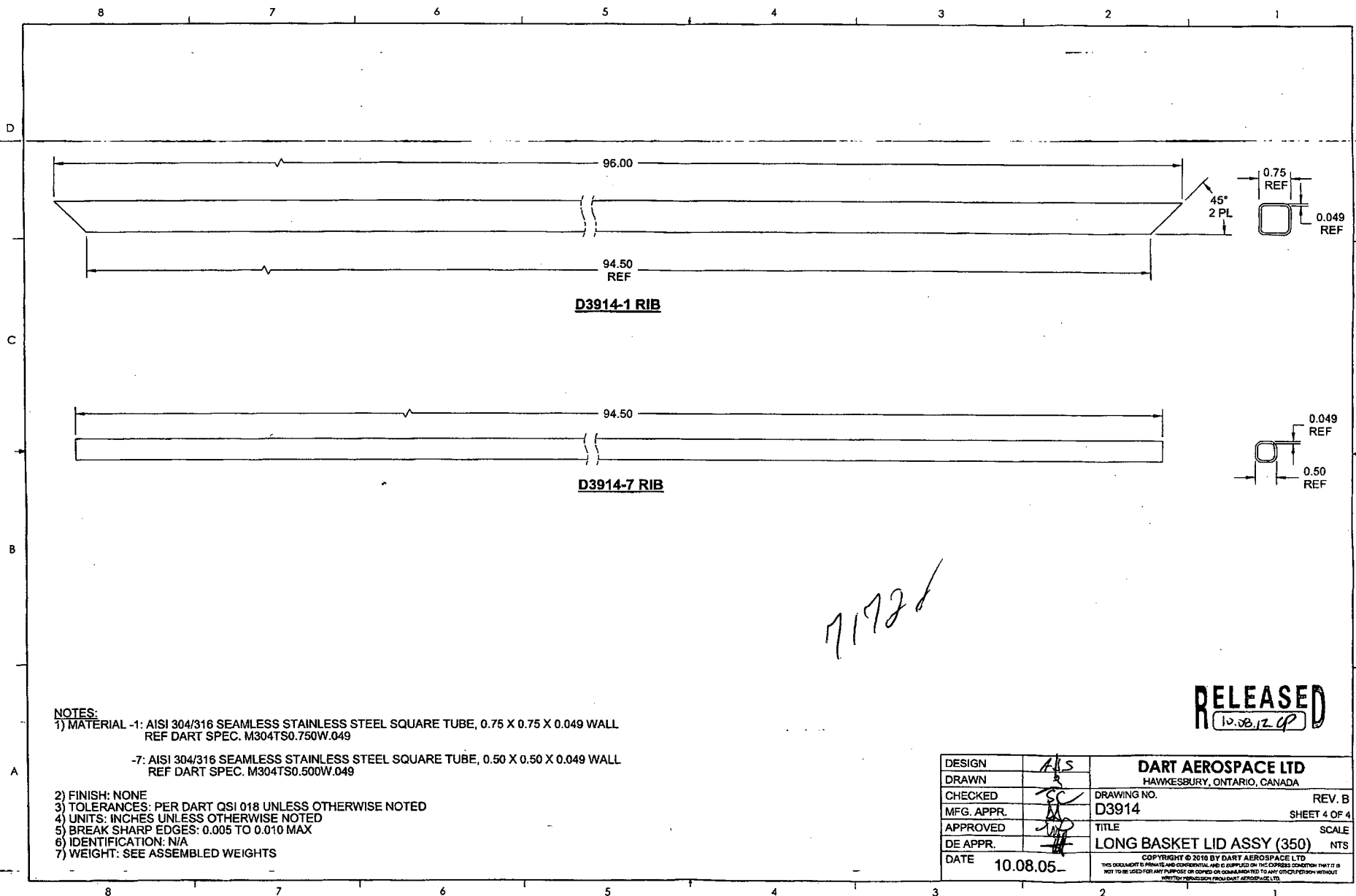
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 4 OF 4
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DE APPR.		LONG BASKET LID ASSY (350) NTS	
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